

Date: Thursday, 3/20/2008 9:54:09 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 02.750 SUPPORT
Job Number : 38124
Estimate Number : 10829
P.O. Number :
This Issue : 3/20/2008 S.O. No. :
Prsht Rev. : NC Part Number : D28931
First Issue : / / Type : MACHINED PARTS Drawing Number : D2893 REV B
Previous Run : 38123 Drawing Revision : B
Material :
Due Date : 4/3/2008 Qty: 20 Um: Each

Written By :
Checked & Approved By : *JA 08 03 20*
Comment : Est: C 02.11.26 Reformat, Added P/O KJ
est D 06.04.19 removed alodine EC
Est Rev: E Added priming as per Rev B 07-04-30 JLM
est F 08.03.19 Re-format EC verified by:
DD

Additional Product

Customer
Job Number

Job Number

Job Number

Seq. #

Machine Or Operation:

Description :

First Issue

DSK078

D2893-1 TURNING DETAIL

Previous Run

Prsht Rev.

Comment: Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)
D2893-1 TURNING DETAIL
Batch: *B 39539*

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

Comment: HAAS 1
Machine as per Folio FA081
Tumble & Deburr

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT ALL DIM TO DIM SHEET

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

POWDER COATING

POWDER COATING

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
Mask Inside Bore for Priming

27/06/2008

S.030 10.38

#1 399.1

#2

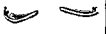
#3

#4

30m 20

B 3812 ✓

D 28931

W/O: 		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/20/2008 9:54:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 38124

Part Number: D28931

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2893 and QSI 005 4.3.

mf 08 07 07

x20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

RT 08-07-11 x20

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

X tube assy

RT 08 07 11 x20

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/14

Job Completion



mf 08-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 38124
Description: Ø2.750 Support	Part Number: D2893-1
Inspection Dwg: D2893 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712							
B	4.946	4.966							
C	3.064	3.084							
D	0.718	0.738							
E	0.090	0.110							
F	2.934	2.954							
G	2.166	2.186							
H	3.890	3.910							
I	0.914	0.934							
J	0.022	0.042							
K	0.109	0.129							
L									
HAAS Section									
AA	2.985	3.005	-	3.004"	3.005	2.999"	3.003"		
AB	0.440	0.460		.440	.440	.380"	.380"		
AC	0.125	0.160		.145"	.130	.140"	.140"	✓	
AD	0.040	0.060		.040"	.043	.040"	.040"	✓	
AE	0.188	0.193		φ.188"	.189	φ.188"	φ.188"		
AF	0.125	0.160		.140"	.140	.141"	.140"		
AG	0.140	0.160		.160"	.148	.140"	.140"		
AH	1.360	1.400		1.381	1.381	1.378"	1.373"		
AI	0.040	0.060		.043	.044	.045"	.045"	✓	
AJ	1.190	1.230		1.218	1.220	1.216"	1.212"		
AK	0.010	0.020		.015"	.015	.015"	.015"		
AL	0.053	0.073		R.063"	R.063	R.063"	R.063"		
AM	0.240	0.260		R.250"	R.250	R.250"	R.250"		
AN	2.518	2.538		2.528	2.530	2.518"	2.518"		
AO	84.39	90.39		84.39"	84.39	84.39"	84.39"		
AP	0.261	0.266		.262"	.264	φ.262"	φ.262"		
AQ	0.053	0.073		R.063"	R.063	R.063"	R.063"		
AR									
AS									
Accept/Reject									

Measured by:	J.F. PML
Date:	08/06/12

Audited by:	LS
Date:	08/06/12

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	

DART AEROSPACE LTD	Work Order: 38124
Description: Ø2.750 Support	Part Number: D2893-1
Inspection Dwg: D2893 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712							
B	4.946	4.966							
C	3.064	3.084							
D	0.718	0.738							
E	0.090	0.110							
F	2.934	2.954							
G	2.166	2.186							
H	3.890	3.910							
I	0.914	0.934							
J	0.022	0.042							
K	0.109	0.129							
L									
HAAS Section									
AA	2.985	3.005		3.003"	3.004"	3.001"	3.002		
AB	0.440	0.460	-	.400"	.400"	.390"	.440		
AC	0.125	0.160		.140"	.135"	.140"	.135		
AD	0.040	0.060		.040"	.040"	.040"	.040		
AE	0.188	0.193		Ø.188"	Ø.188"	Ø.188"	.188		
AF	0.125	0.160		.144"	.144"	.141"	.142		
AG	0.140	0.160		.150"	.144"	.140"	.143		
AH	1.360	1.400		1.395"	1.377"	1.381"	1.377		
AI	0.040	0.060		.043"	.044"	.045"	.044		
AJ	1.190	1.230		1.213"	1.230"	1.219"	1.215		
AK	0.010	0.020		.015"	.015"	.015"	.015		
AL	0.053	0.073		R.063"	R.063"	R.063"	.063		
AM	0.240	0.260		R.250"	R.250"	R.250"	.250		
AN	2.518	2.538	-	2.476"	2.480"	2.476"	2.525		
AO	84.39	90.39		87.390	87.39	87.39"	87.39		
AP	0.261	0.266		Ø.262"	Ø.262"	Ø.262"	.262		
AQ	0.053	0.073		R.063"	R.063"	R.063"	.063		
AR									
AS									
Accept/Reject									

Measured by: J.F.
Date: 08/06/17/JL

Audited by: J.S.
Date: 08/06/17

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	

DART AEROSPACE LTD	Work Order: 38124
Description: Ø2.750 Support	Part Number: D2893-1
Inspection Dwg: D2893 Rev. B	Page 1 of 1

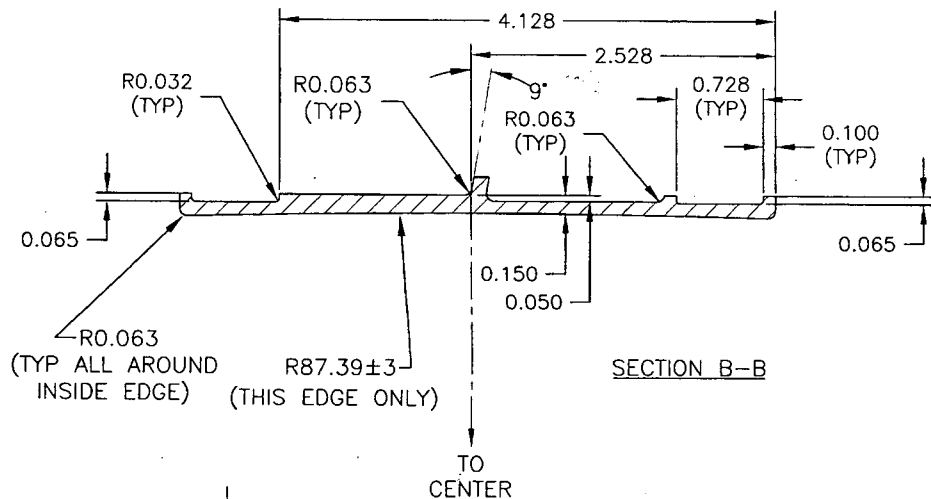
Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712							
B	4.946	4.966							
C	3.064	3.084							
D	0.718	0.738							
E	0.090	0.110							
F	2.934	2.954							
G	2.166	2.186							
H	3.890	3.910							
I	0.914	0.934							
J	0.022	0.042							
K	0.109	0.129							
L									
HAAS Section									
AA	2.985	3.005		3.000	3.000				
AB	0.440	0.460		.440	.440				
AC	0.125	0.160		.132	.131				
AD	0.040	0.060		.043	.042				
AE	0.188	0.193		.188	.188				
AF	0.125	0.160		.140	.140				
AG	0.140	0.160		.144	.143				
AH	1.360	1.400		1.377	1.379				
AI	0.040	0.060		.044	.046				
AJ	1.190	1.230		1.215	1.218				
AK	0.010	0.020		.015	.015				
AL	0.053	0.073		.063	.063				
AM	0.240	0.260		.250	.250				
AN	2.518	2.538		2.525	2.520				
AO	84.39	90.39		87.39	87.39				
AP	0.261	0.266		.262	.262				
AQ	0.053	0.073		.063	.063				
AR									
AS									
Accept/Reject									

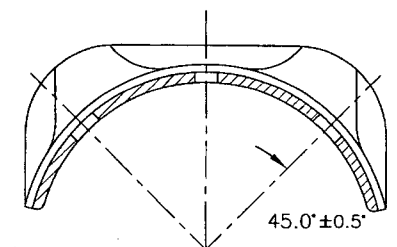
Measured by:	J.L.
Date:	08/06/18

Audited by:	[Signature]
Date:	08/06/24

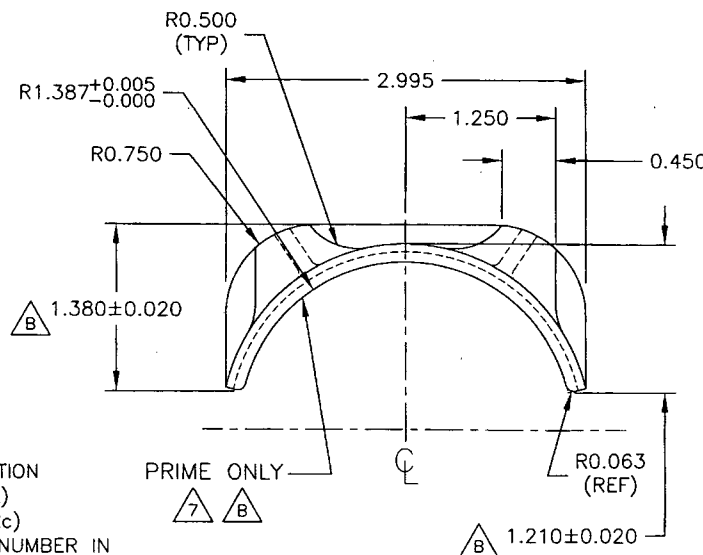
Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	[Signature]



SECTION B-B



SECTION A-A
TOOLING HOLE DETAIL



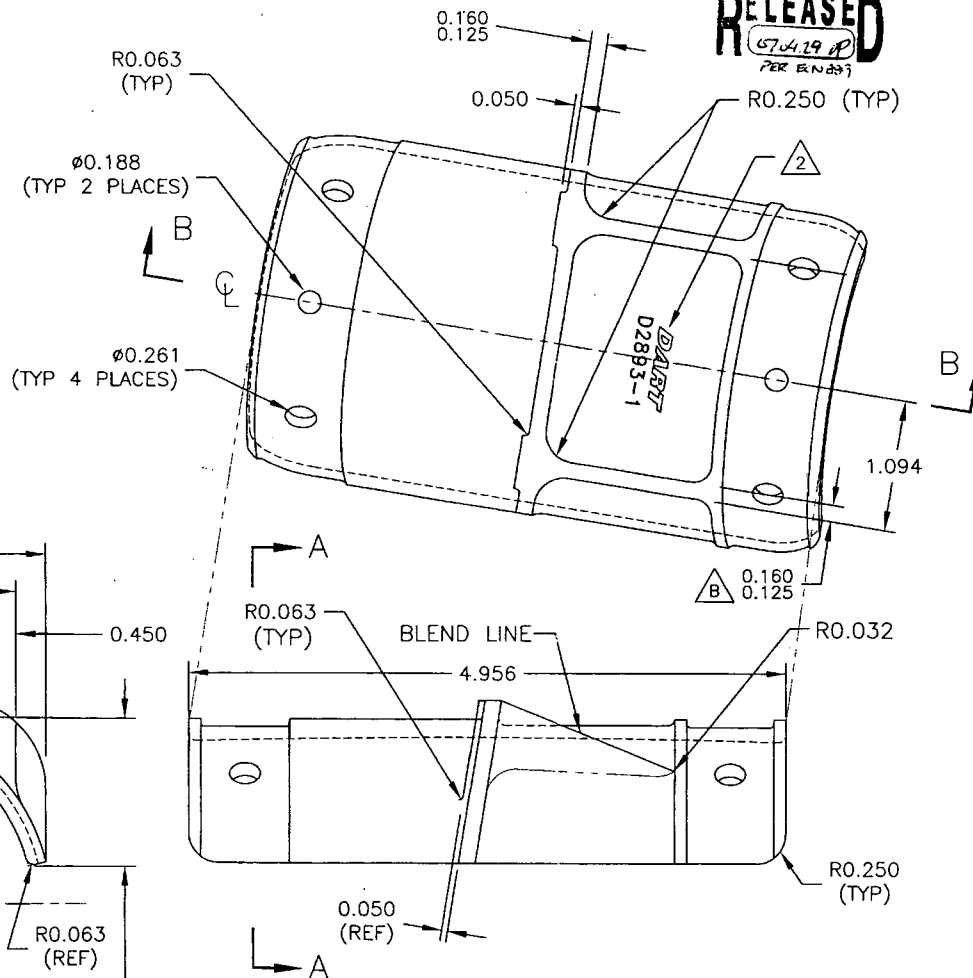
PRIME ONLY
7 B

B 1.210±0.020

D2893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

NO. 38124
WORK ORDER
UNCONTROLLED COPY
ENGINEERING
RETURN TO
WITHOUT NOTICE



RELEASED
67419 IP
PER EN283

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	GP	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.03.16	
DRAWING NO.	D2893	
TITLE	02.750 SUPPORT	
REV. B		
SHEET 1 OF 1		
SCALE	1:1	

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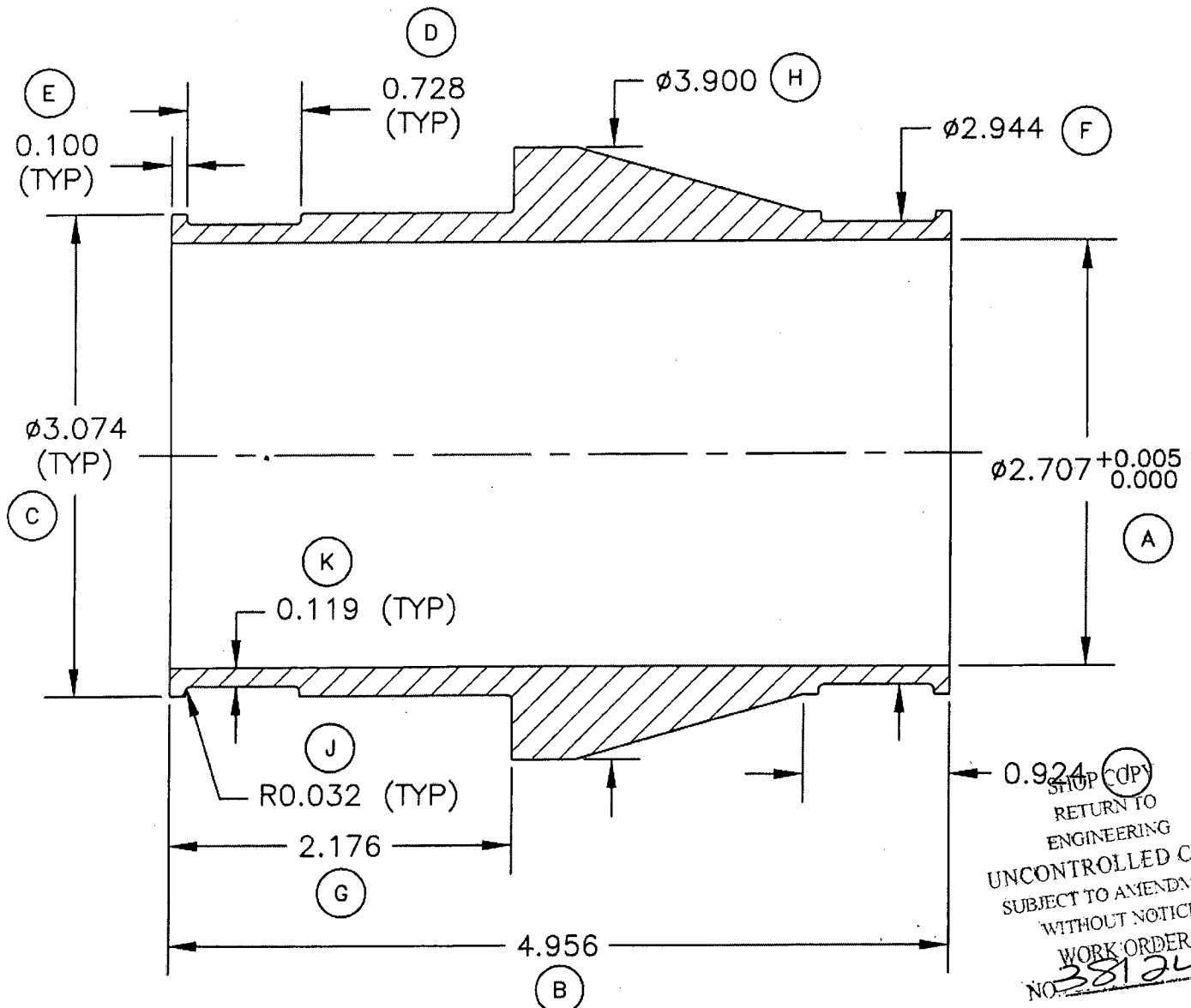
DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2893-1 TURNING DETAIL

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